

Work Order ID 157401

157401

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Tuesday, February 21, 2017 1:13:37 PM

Item ID: D3174-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 2/27/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 3/6/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference: 10-3-2017
24-3-2017

Approvals: Process Plan: DAS 21 Date: MAR 07 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3174	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.07							
FLOW CNC Waterjet	1-Cut as per Dwg D3174 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

10 02/17/03/11

10 02/17/03/11

10 DAS 38 9-89
MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 157401***157401***

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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging									
Packaging									
	Memo *****STOCK IN BASKET CELL***** LOCATION : WA004	0.01							
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.13							
Quality Control									

17/3/14

MAR 13 2017

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 157401

157401

Parent Item: D3174-1

D3174-1

Parent Item Name: Mounting Lug

Start Date: 2/27/2017

Required Date: 3/6/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A03.01.29New issueKJ/RF
IPP Rev:B 08-08-19 now made on water jet DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased			No	100	sf	42.8600	0.0408	0.343579			

M304S12GA

304/316 0.100" Sheet

2/17/03/11

Location

Loc Qty

Loc Code

MAT019

42.86

m131322

14

m136687

28.86

16

DQA: _____ Date: _____

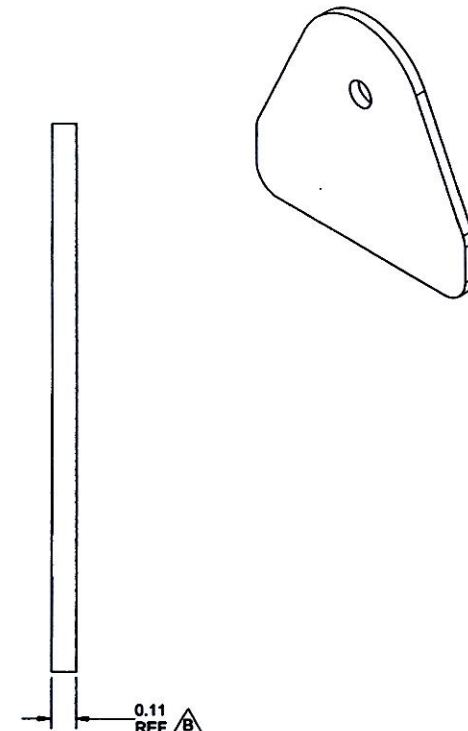
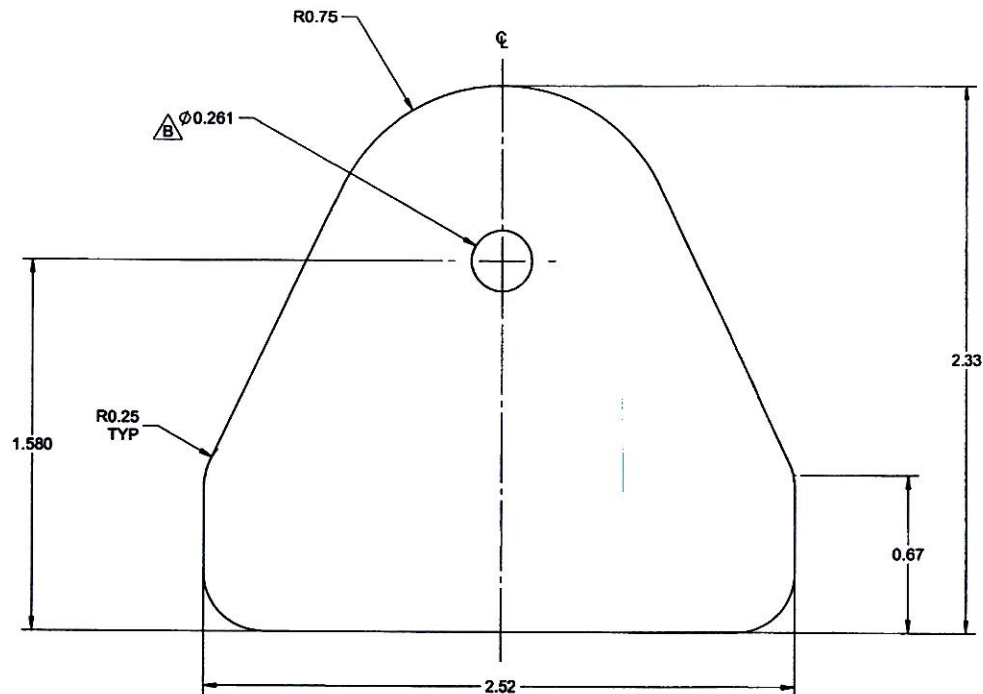


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OTHER : _____					



D3174-1 MOUNTING LUG

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET, 12 GAUGE $\triangle$
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC M304S12GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.14 lbs

**SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER**

NO. 157401 *AL5*
1703-07

RELEASED

2016 NOV 02
 EON 16-93 97

B	REFORMAT DRAWING, REVISE SHEET THICKNESS (ZN B2-1, A7-1) 0.0261 WAS 0.0257		VS	15.11.09
A	NEW ISSUE		CP	02.12.03
REV.	DESCRIPTION		BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED	RF		DRAWING NO. REV. B	
MFG. APPR.	DD	D3174	SHEET 1 OF 1	
APPROVED	HS	TITLE	SCALE	
DE APPR.	DS	MOUNTING LUG	NTS	
DATE	15.11.09	COPYRIGHT © 2002 BY DART AEROSPACE LTD		
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